



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2801-041

Job Sheet 184961



SOLD Alone

Part No: D2801-041

Job Qty: 1 ea

Part Name: Step Assembly LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/19/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D2801 REV.A1 IPP REV:A 14.04.15 NEW ISSUE DD VERF:JLM,

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/14/18	0.00	0.00	Start Up Large Fab-4		CPC
100	Large Fab	1 pcs		12/14/18	0.00	1.47	Large Fab 8		CPC
110	QC	1 pcs		12/14/18	0.00	0.00	QC6		PD 13-10-24
120	Large Fab	1 pcs		12/14/18	0.00	1.47	Large Fab 2		CPC
130	QC	1 pcs		12/14/18	0.00	0.00	QC9		PD 13-10-24
140	QC	1 pcs		12/14/18	0.00	0.00	QC5		PD 13-10-24
150	HandFinish	1 pcs		12/14/18	0.00	0.37	HandFinish1		CPC
160	QC	1 pcs		12/14/18	0.00	0.00	QC7-1		CPC
170	Large Fab	1 pcs		12/14/18	0.00	1.47	Large Fab 2		CPC
180	QC	1 pcs		12/14/18	0.00	0.00	QC10		CPC
190	QC	1 pcs		12/14/18	0.00	0.00	QC5		CPC
191	HandFinish	1 pcs		12/14/18	0.00	0.37	HandFinish2		CPC
200	Powdercoat	1 pcs		12/14/18	0.00	0.24	Powdercoat1		BR/DR 18/10/26
210	QC	1 pcs		12/14/18	0.00	0.00	QC3		BR/DR 18-10-29
220	HandFinish	1 pcs		12/14/18	0.00	0.37	HandFinish4		BR/DR 18-10-29
230	QC	1 pcs		12/14/18	0.00	0.00	QC5		BR/DR 18-10-29
240	Packaging	1 pcs		12/14/18	0.00	0.00	Packaging3-1		OC OCT 30 2018 68
250	QC21-SA	1 Ea		12/14/18	0.00	0.00	QC21		OC OCT 30 2018 9-89

Part Op 100 - 1-Cut D2622 extrusion to 86.15" long as per Dwg D2801 2-Deburr and bevel ends for welding

Descriptions: 120 - ***Press fit bushing before weldig*** 1-Weld Arms as per Dwg D2801 2-Weld (1) Cap as per Dwg D2801 3-Grind end cap welds flush

170 - 1-Weld last arm as per Dwg D2801 2-Weld last end cap as per Dwg D2801 3-Grind end cap welds flush Inspect for foreign object per QSI 024

191 - ***Touch up step with alodine per qsi 005 prior to powder coat***

1138951 200 - START TIME: 8:10 OVEN TEMPERATURE: 320° FINISH TIME: 8:40

220 - Wing Walk per Dwg D2801 and QSI 005 4.4

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	1 Ea (1 ea)	90-Start up Operation	S1040017
D2734	Step End Plate	2 Ea (2 ea)	90-Start up Operation	5077383
D2802-1	Arm	2 Ea (2 ea)	90-Start up Operation	F116467
D2808	Spacer	2 Ea (2 ea)	90-Start up Operation	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS				
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
--------------	---------------	-----------------------	-----------------------

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	1	26	0
	D2734	2	27	0
	D2802-1	2	2	0
	D2808	2	32	0

Part Specifications

Specifications could not be found.

Plex 10/19/18 11:18 AM Dart.lajeunesse.marie



Container No: S120818



Part: D2801 - 041

Job No: 184961

Serial No/Batch: S120818

Revision: A1

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/24/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

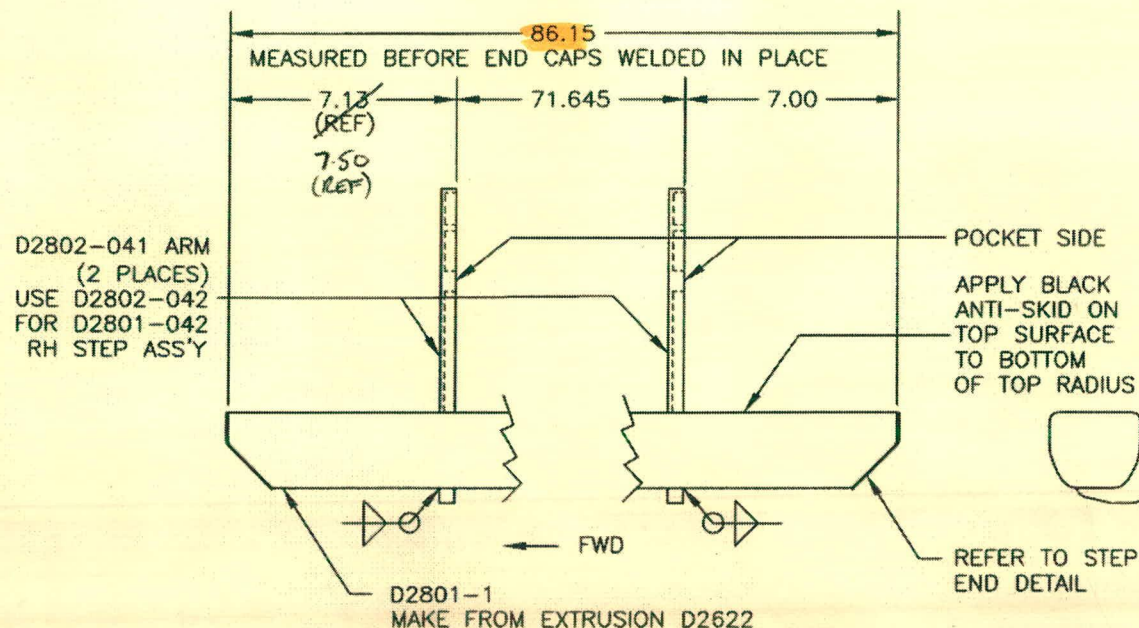
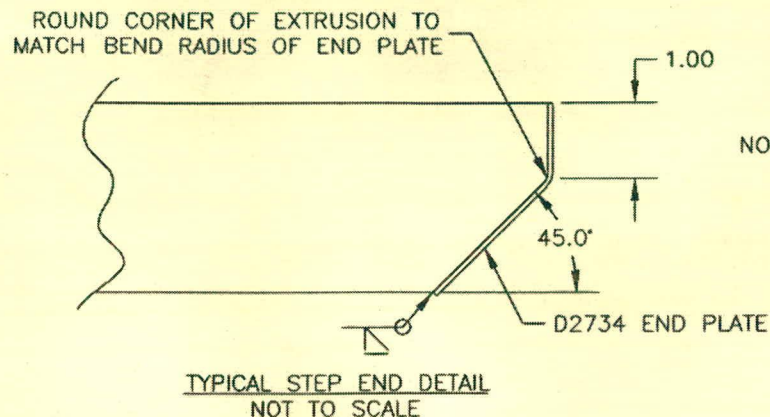
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DART

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



D2801-041 LH STEP ASSEMBLY (SHOWN)
D2801-042 RH STEP ASSEMBLY (OPPOSITE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAMKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. A
00.11.03	STEP WELDMENT	SHEET 1 OF 1
A	00.11.03	SCALE
ALL	03.08.15	NTS
	NEW ISSUE	
	7.50 WTS 7-13	

RELEASED
00.11.13

